Work Orde Friday, February				*9	7352*						Fa		M Page 1
Revision ID:	D3876-9 Protector - RH	Aft Wall		Accept	*N9	ንበና	<u>)</u> 040	100)*	Setup	Start Stop	ı VI ,	S1*
	2/15/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			t Item tomer:					•	"IN	S2*
Approvals:	Process Pla	n: MWC	Date: (3-2-19)	Tooling: SPC (Y/N)	:		Date:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Ho		ool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	 , ,	sion Nbr											
D3876	A					-	- -						-
100 Waterjet FLOW CNC Waterjet	t	FLOW WATER JET Memo 1-Cut as per Dwg Rev: Prog Rev: 2- Deburr if	r Dwg D3876 A f necessary	0.00					6		٥_		Jm13-2-2
*110 *110* QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00					6,	-· -· 	<u>5</u>	- -	Jm 13-2-20
*120		QC8- Inspect parts - seco	ond check	0.00	AS 15				6				
QC Quality Control		Memo		0.00	⁵ 3 · 9 l					·			

NCD.	Voc	1	Nia
NCR:	Yes	/	Nο

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

NCR: Y	es / INO				WORK ORDER WORK	COMON	IVIAITEL / OF		QA Closed:	Date	S:
Work Orde	r.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
		· · · · · ·			Rework]	Skid-tube	Crosstube	D	Water Jet	Engineering Quality
Part N	0.				Scrap	-1 1	Machining	Small Fab	1	d. Eng. Coor.	
NCR N	lo				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling									:		
Operator							ļ				
Material											
Setup											
Other											
Process											
Supplier											
Fraining		[
Jnapproved											
						AULT CAT	EGORY				
Landir	ng Gear			_	General				٦	г	
	Bending			ļ	Bend	Grain			Ovalized	Ļ	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardw		ļ <u></u>	Over/Under	<u>+</u>	Temperature/Cure
	Cracks			_	Broken/Damaged	├ ─┪ `	tion Incomplete		Part Incorre	-	Weld
	Crushed/	Crimped	-	<u> </u>	Burrs		tions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination	⊢	enance		Part Moved		
	Heat Trea	at			Countersink	Mislab	eled	<u> </u>	Positioned \	r	 -1
	Inspectio		Tube		Cut Too Short	Misrea		L_	Power Loss,	/Surge	Other
Į	Ripples in	Bend			Drill Holes	Offset					
	Torque W	/aves in [Extrusio	n L	Drawing	├ ─┤	Calibration				
	Turning S	equence			Finish	Out of	Sequence				MANAGE CONTRACTOR OF THE STATE
	Wave/Tw	ist in Tul	be		Folio	Outsid	le Dimensions				

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Friday, Februar	ry 15, 2013 2	2:57:57 PM			1:1/							1 450 2
Item ID: Revision ID: Item Name:	D3876-9 Protector - R	H Aft Wall		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	2/15/2013 : 2/22/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					IV.	
Approvals:	Process Pl QC:	lan:	Date:			nte:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & St Memo	ock Location: PPP 97341	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC21- Final Inspection -	· Work Order Release	0.00						/	/3/s	1 25 X

											DQA:	Da	ate: _	₽ . ,
NCR:	res / N)			WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		QA Closed:	D:	ate:	*
					<u> </u>						QA Closea.	0.	ite.	
Work Orde	ar.				DISPOSITION				AGAINST I	DEI	PARTMENT	PROCESS		
Part N	•				Rework Scrap Use-as-is		ſ	Skid-tube Machining	Crosstube Small Fab Finishing			Water Jed d. Eng. Coor e/Packaging		Engineering Quality Other
NCR N	No				Work Order Update	}	•	Large Fab	Composite			Supplie	_	
Root				Descri	ption of work order update	T	Initial	Ac	ction		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data													İ	
Equip/Tooling										-		:		
Operator														
Material														
Setup		İ											1	
Other													ł	
Process	Ш													
Supplier													ŀ	
Training											<u> </u>			
Unapproved				<u> </u>							<u> </u>			
					<u> </u>	AUI	LT CATE	GORY						
Landi	ng Gear				General		٦		,		7			1
	Bendir	ıg			Bend	<u> </u>	Grain				Ovalized			Pressure/Forced
	Centre	Not Conce	ntric to	O/S	BOM/Route	<u> </u>	Hardwa	ire	ļ		Over/Under	tolerance	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged			ion Incomplete			Part Incorre		<u> </u>	Weld
	Crushe	d/Crimped	l.	<u> </u>	Burrs	<u> </u>	-	ions Incomplete,	/Unclear		Part Lost/M	issing		Wrong Stock Pulled
1	Cuffs				Contamination	1	Mainte	enance	ļ		Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Picklist Print

Friday, February 15, 2013 2:57:57 PM

Work Order ID:

97352

Parent Item:

D3876-9

Parent Item Name:

Protector - RH Aft Wall

Start Date: 2/15/2013

Required Date: 2/22/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Oty	Qty Issued	Date Issued	Status	
MLEXS.125-F60029-04		Purchased	No			100	sf	0.0000	3.14	19.831579				-
GE PLASTICS LEXAN SH	EET									200				2

124655

124655

											DQA:	Date:	P	•
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP				T-	
···						* ***********************************					QA Closed:	Date:		
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
VVOIR OTAL	٠				·····	Rework	7		Skid-tube	Crosstube		Water Jet	Engineerin	g
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Qualit	
	•					Use-as-is	1	1	noforming	Finishing	ł	re/Packaging	Othe	r
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier		
						<u> </u>	_					_		
Root						ption of work order update		Initial		tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC inspe	ctor
Doc/Data														
Equip/Tooling														
Operator	Ш													
Material													Ì	
Setup			ļ								İ			
Other														
Process														
Supplier														
Training							İ							
Unapproved														
						F	AUI	LT CATE	GORY				·	
Landi	ing G	Gear				General		-			_	-	•	
		Bending				Bend		Grain			Ovalized	<u></u>	Pressure/Ford	ced
Į		Contra No	ot Conce	ntric to	n/s	BOM/Route		Hardwa	ıre	į	Over/Under	tolerance	Temperature	/Cure

	Centre Not Concentric to 0/3	1	I DOM/ Noute	L	Thatawaic	L_	Joven/onder tolerance		1 remperature, care
	Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld
	Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled
	Cuffs		Contamination		Maintenance		Part Moved		
	Heat Treat		Countersink		Mislabeled		Positioned Wrong	_	_
Γ	Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge	L	Other
Γ	Ripples in Bend		Drill Holes		Offset				
	Torque Waves in Extrusion		Drawing		Out of Calibration				
Γ	Turning Sequence	Г	Finish		Out of Sequence				
Ī	Wave/Twist in Tube		Folio		Outside Dimensions				

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DART AEROSPACE LTD	Work Order:	97352
Description: Protector – RH Aft Wall	Part Number:	D3876-9
Inspection Dwg: D3876 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030). aò''	_		V	Itmol
24.25	+/-0.030	24.25"	-		T	Jkmob
16.98	+/-0.030	16.99"	_		丁	
17.77	+/-0.030	17.77"	_		T	
11.85	+/-0.030	11.85"	_		V	Preturos
10.44	+/-0.030	1044"	,		V	
0.125	+/-0.010	G136"	_		V.	

		20		
Measured by:	Jm	Audited by:	Prototype Approval:	N/A
Date:	13-2-20	Date: 3 2 2	Date:	N/A

Rev	Date	Change	Revi	sed	by	Approved
Α	09.06.22	New Issue	KJ	*	+	AL
				-7	/	

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														~
												QA Closed:	Date:	
Work Order:							DISPOSITION		AGAINST DEPARTMENT/PROCESS Skid-tube Crosstube Water Jet Engineering					
Part No							Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier		Quality
Root Descri							tion of work order update		Initial Action			Sign &		
Cause	D.	Date Step		l		•	or Non-conformance		ief Eng	Descri		Date	Verification	QC Inspector
oc/Data	100	ie	step	Qty			· · · · · · · · · · · · · · · · · · ·	-	icr ciig	Descri	ption	Dute	7 0 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	
quip/Tooling	\dashv	- 1												
perator	-	1												
Naterial	-													
etup	-	-												
Other	1													
rocess	-				•									
upplier	\dashv													
raining														
Inapproved	-													
FAULT CATEGORY														
Landin	g Gear			·			General							
ſ	Bending						Bend	Grain				Ovalized		Pressure/Forced
ŀ		Centre Not Concentric to O/S					BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure	
Ţ	_	Cracks					Broken/Damaged		Inspection Incomplete			Part Incorrect		Weld
1		Crushed/Crimped.					Burrs		Instructions Incomplete/Unclear		Inclear	Part Lost/Missing		Wrong Stock Pulled
Ì		Cuffs					Contamination	Maintenand		enance		Part Moved		_
t	_	Heat Treat					Countersink	Mislabeled		eled		Positioned V	Positioned Wrong	
ţ	-	Inspection Strip in Tube					Cut Too Short		Misread		Power Loss/Surge Other		Other	
ţ	- '	Ripples in Bend					Drill Holes		Offset					
Ì		Torque Waves in Extrusion					Drawing		Out of Calibration					
Ì		Turning Sequence					Finish		Out of Sequence					
ľ	_	Wave/Twist in Tube					Folio		Outside Dimensions					-

DQA:

Date:

